

Work Order ID 62914

Wednesday, October 13, 2010 11:47:39 AM

Page 1

Item ID: D4073-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Hinge

Start Date: 10/13/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-16-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4073

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 3.875" long

105

0.00



HAAS 1

Memo

0.00

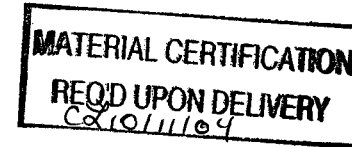
HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev:

Folio Rev:

Deburr



SK 10/11/03

Work Order ID 62914

Wednesday, October 13, 2010 11:47:39 AM

Page 2

Item ID: D4073-1

Accept

Revision ID:

Item Name: Door Hinge

Start Date: 10/13/2010 Start Qty: 2.00

Required Date: 10/22/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:




Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2	0		
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2	0		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	0		

Work Order ID 62914

Wednesday, October 13, 2010 11:47:39 AM



Page 3

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Item Name: Door Hinge

Stop



Start Date: 10/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

M115291.
START: 9:25
OVENT: 320°
FINISH: 9:55

0.00

2 BR 10-11-14

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=1 10/11/10/14

2 0

180



Packaging

Packaging

Identify as per dwg & Stock Location:

122

0.00

Memo

0.00

10/11/14 120

Work Order ID 62914

Wednesday, October 13, 2010 11:47:39 AM

Page 4

Item ID: D4073-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Hinge

Start Date: 10/13/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10.11.08**10.11.07*

Picklist Print

Page 1

Wednesday, October 13, 2010 11:47:43 AM

Work Order ID: 62914

Parent Item: D4073-1

Parent Item Name: Door Hinge



Start Date: 10/13/2010

Required Date: 10/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	28.7889	0.3333333	0.666667			



6061-T6 Bar 2.00 x 1.25



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	28.7889	
114407	16.7889	
114899	12	

666 *m 10/11/02*

*S/B
114507
has been fixed
W*

62914

DART AEROSPACE LTD		Work Order: 627
Description: Door Hinge		Part Number: A4073-1
Inspection Dwg: A4073 Rev: 1		Page 1 of 1

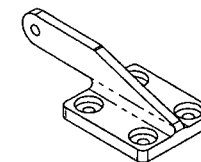
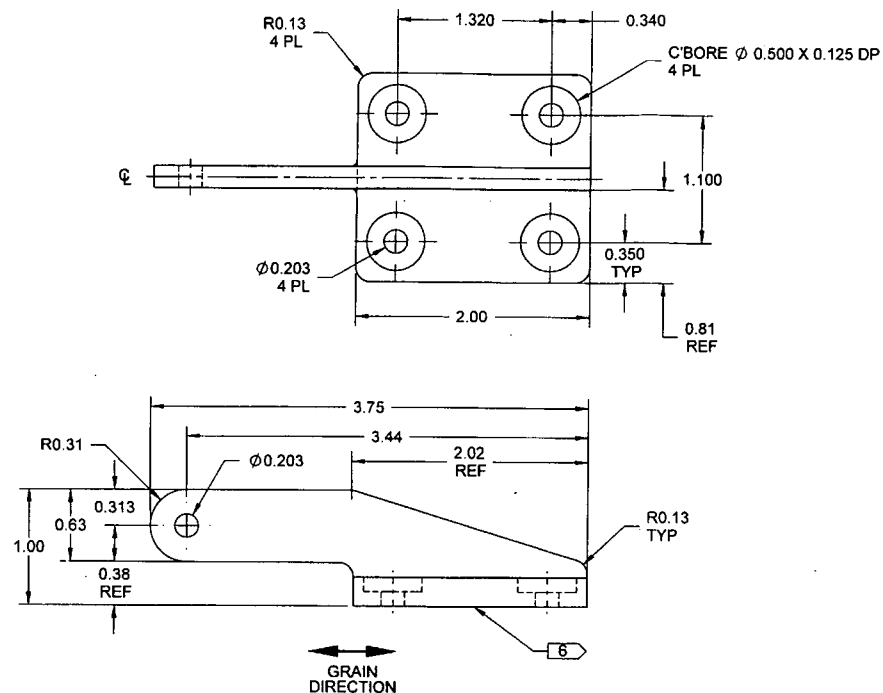
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.320	$\pm .010$	1.321	/		Vern.	SD-9
.340	$\pm .010$.340	/			
0.500 X .125	$\pm .010$	0.503 X .126	/			
1.100	$\pm .010$	1.100	/			
.350	$\pm .010$.350	/			
.81	$\pm .030$.803	/			
2.00	$\pm .030$	1.999	/			
0.203	$\pm .001$	0.205	/			
3.75	$\pm .030$	3.750	/			
3.44	$\pm .030$	3.439	/			
1.00	$\pm .030$.990	/			
.63	$\pm .030$.614	/			
.313	$\pm .010$.3125	/			
.38	$\pm .030$.380	/			
2.13	$\pm .030$	2.125	/			
.190	$\pm .010$.190	/			
.25	$\pm .030$.245	/			
1.80	$\pm .030$	1.800	/			

Measured by: <i>SA</i>	Audited by: <i>AK</i>	Preliminary Approval:
Date: 10/11/03	Date: 10/11/03	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



NO. 62914
10-10-0

D4073-1 DOOR HINGE

RELEASED
2010-09-03

NOTES:

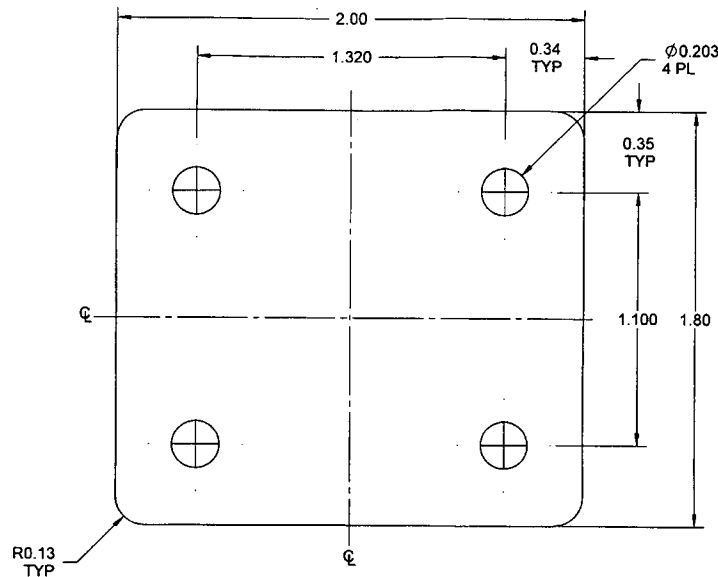
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

A NEW ISSUE		RF		10.09.16
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF			
DRAWN	RF			
CHECKED	RF			
MFG. APPR.	RF			
APPROVED	RF			
DE APPR.	RF			
DATE	10.09.16			

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4073** REV. A
SHEET 1 OF 2
TITLE **DOOR HINGE** SCALE NTS

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D4073-3 DOOR HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2010-09-23
ND

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	ND	DRAWING NO.	REV. A
MFG. APPR.	ND	D4073	SHEET 2 OF 2
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	DOOR HINGE	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Receiving Report

Date: 10/4/27
 Supplier: MAGNA

Batch No: M114507
 Dart P/O: 11708

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 1064/08 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	6B 1.000 V 15.000	72	0	0	72	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 10/4/27
 Date
 Received/Costing [Signature]
 Initial

Location _____



Magna Stainless

5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I0263

SOLD TO:

00003858
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR:Y

INVOICE DATE:	04/28/10
ORDER DATE:	04/27/10
SHIP DATE:	04/28/10
ORDER NUMBER:	W028849
PURCHASE ORDER:	P011758

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		1	PC	ALUMINUM ANGLES AAN 6061 T6 4" x 4" x 1/4" x R/L L036000 20' 1 PC/46 LB	1 UN	105.00	105.0
		2	PC	ALUMINUM FLATS AFL 6061 T6 1-1/4" x 2" x R/L L037998 20' 2 PC/118 LB	2 UN	135.00	270.0

RECEIVED MAR 03 2010

04/29/10 13:17:24

PST Exmp No:EXEMPT

Merchandise:	375.00
Surcharges:	
No Tax Costs:	
GST	18.75
Total Due:	393.75

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 12% per annum.

OST # 1212236471

April 28, 2010 8:56:02 AM

All Vendors PO ID PO11758 Receipt Dates from 4/28/2010 to 4/28/2010 All Line Item Types

Grouped by Vendor ID

[illegible]



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I026315

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID



MTR:Y

SPECIAL INSTRUCTIONS

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P011758	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W028849	NET 30 DAYS	NIR:R-557065-1	04/27/10	04/28/10	04/28/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM ANGLES AAN 6061 T6 4" x 4" x 1/4" x R/L 20' 46 LB / 1 PC	L036000	8820	1
2		PC	ALUMINUM FLATS AFL 6061 T6 1-1/4" x 2" x R/L 20' 118 LB / 2 PC	L037998	47825	2
indles: 1				Approx Weight:		164 LB



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11758

Purchase Order Date 4/27/10

PO Print Date 4/27/10

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

FAXED
4/27/10

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6A4.000W.250	6061T6 ANGLE 4.00 x 4.00 x .250	4/30/10 Yes	✓ 20.00 f	Yours ppd	\$5.2500	\$105.00
		Special Inst: MATERIAL: 6061-T6/T6511 ALUMINUM ANGLE AS PER QQ-A-200/8					
2	M6061T6B1.000X15.000	6061-T6 Bar 1.00 x 15.00	5/06/10 Yes	72.00 f1	Yours ppd	\$52.5000	\$3,780.00
		Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 MATERIAL IS CUT FROM PLATE **PLEASE CUT AT 12FT LONG**					
3	M6061T6B2.000X01.250	6061-T6 Bar 2.00 x 1.25	4/30/10 Yes	✓ 40.00 f	Yours ppd	\$6.7500	\$270.00
		Special Inst: AS ABOVE					

Change Nbr: 1

Change Date: 4/27/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO11758**

Purchase Order Date 4/27/10

PO Print Date 4/27/10

Page Number 2 of 2

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

PO Total:

\$4,155.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 4/27/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Material Test Report

Customer Ship To:

Magna Stainless Inc.
5775 Kieran St.

St-Laurent
QB H4S 0A3

8/10/10/28

Our Order: 833838 - 1

Your PO # PO08677

Part # 05904-000-240

Die: LS05904

Description: 4.00 x 4.00 x .250

Alloy Temper: 6061 T6

Print Date: 2/2/2010

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-.40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties

Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
5120	1/28/10	<u>8820</u>	44.20	41.97	17.0

Applicable Specifications: ASTM B221-08 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized

Evan Eng

Evan Eng, Quality Assurance Mgr.

100077 (C410)

325 rue Avro
Pointe-Claire, QC, Canada, H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310

sapa:

Test de dureté Rockwell Rockwell Hardness Test

Client / Customer : **MAGNA STAINLESS INC.**

Adresse / Address : **5775 RUE KIERAN
SAINT LAURENT, QUEBEC
H4S 0A3**

commande Sapa/ Sapa order # : **32161**

bon de commande / Purchase order # : **P009572**

de matrice / Die # : **MS 16382**

Description : **2" X 1 1/4" FLAT BAR**

Alliage & trempage / Alloy & temper : **6061 T6**

Customer Part # : **N/A**

Contrôle / Control # : **16661-1**

Coulée / Cast # : **47825**

Dureté Rockwell E /
Rockwell E hardness : **92 HRE**

Min. requis /
Min. required : **88 HRE**

Max. permis /
Max. permitted : **100 HRE**

Composition chimique typique / Typical chemical composition :

Alliage/Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,66 - 0,74	0,14 - 0,28	0,08 - 0,16	0,18 - 0,26	0,46 - 0,54	0,03 Max	0,05 Max	0,05 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et **AMS QQA 200/8** excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and **AMS QQA 200/8** except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : **2010-04-06**

Michel Lefebvre

Michel Lefebvre
Technicien de la qualité
Quality technician

C 2782

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	ALS4-1032-130 / Insert	Main Warehouse ST282	61220	QUIR01		197.0000		159.0000		
		Main Warehouse ST282	61586	QUIR01	8/11/10	-16.0000 153.0000	114407	-16.0000 143.0000		-\$2.08
		Main Warehouse ST282	53062	LAVO01	9/03/10	-16.0000 137.0000	114407	-16.0000 127.0000		-\$2.08
		Main Warehouse ST282	61888	DESJ02	9/13/10	-10.0000 27.0000	114407	-10.0000 17.0000		-\$1.30
		Main Warehouse ST282			9/14/10	-17.0000	114407	-17.0000		-\$2.21
								-1,648.0000		-\$214.24
	M6061T6B2.000X01.250 / 6061-T6 Bar 2.00 x 1.25	Main Warehouse MAT	57925	DCUSER		40.0000		40.0000		
		Main Warehouse MAT	57924	FAUT01	5/18/10	-10.9200 29.0800	114407	-10.9200 29.0800		-\$83.96
		Main Warehouse MAT	59612	FAUT01	6/10/10	-10.4000 30.6800	114407	-10.4000 18.6800		-\$79.96
		Main Warehouse MAT	61525	DCUSER	6/14/10	-0.3333 30.3467	114407	-0.3333 18.3467		-\$2.56
		Main Warehouse MAT	61529	DCUSER	9/13/10	-0.7789 29.5678	114407	-0.7789 17.5678		-\$5.99
		Main Warehouse MAT	62795	DCUSER	9/13/10	-0.7789 28.7889	114407	-0.7789 16.7889		-\$5.99
		Main Warehouse MAT	62914	DCUSER	11/02/10	-0.6667 28.1222	114407	-0.6667 16.1222		-\$5.13
		Main Warehouse MAT			11/02/10	-0.6667	114407	-0.6667		-\$5.13
								-24.5445		-\$188.72

*B/N
should
reze
114507*